

Work Order ID 53712-1 in split 1



November 13, 2009 9:56:05 AM

Item ID: D3594-043
Revision ID: B
Item Name: Floor Doubler Assembly, LH

Accept



Setup Start



Stop



Start Date: 13/11/2009 Start Qty: 1.00

Required Date: 20/11/2009 Req'd Qty: 7.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: PL Date: 09-11-13 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3594	Rev B
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100

0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg D3594 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 9-11-13

⑧

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B 9-11-13

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

27802/11/13

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53712

November 13, 2009 9:56:05 AM



Page 2

Item ID: D3594-043
 Revision ID: B
 Item Name: Floor Doubler Assembly, LH
 Start Date: 13/11/2009 Start Qty: 7.00
 Required Date: 20/11/2009 Req'd Qty: 7.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:
 Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	C'SINK AS PER DWG D3594								
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

Handwritten signature and date: 09/11/23 (8)

Handwritten circled numbers: 1043 and 15

Handwritten note: => 8 on 11/23

Handwritten note: MD 09/11/30

Handwritten mark: x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53712

November 13, 2009 9:56:05 AM



Page 3

Item ID: D3594-043
Revision ID: B
Item Name: Floor Doubler Assembly, LH

Accept



Setup Start



Stop



Start Date: 13/11/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

OK 09-11-30



170



Small Fab

Small Fab

Small Fab

Memo

Install Nut Plates As per Dwg D3594

0.00

0.00

0512/01/12 (S)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 506/1/13



0043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53712

November 13, 2009 9:56:05 AM



Page 4

Item ID: D3594-043
Revision ID: B
Item Name: Floor Doubler Assembly, LH

Accept



Setup Start



Stop



Start Date: 13/11/2009 Start Qty: 7.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging Packaging	Identify as per dwg & Stock Location: <i>234B</i> Memo	0.00 0.00							
200 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/01/14 (5)

10/01/15

ME

10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 13, 2009 9:56:11 AM

Page 1

Work Order ID: 53712

Parent Item: D3594-043RevB

Parent Item Name: Floor Doubler Assembly, LH


Comments:

Start Date: 13/11/2009

Required Date: 20/11/2009

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-4  Rivet		Purchased	No			100	Each	3,000.000	14.0000		9/11/30	sf (8x)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3000

15541

3000

M6061T6S.080

Purchased

No

170

sf

194.4599

3.7579



6061-T6 .080 Sheet

(14x)

18 9-11-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

194.45987

107904

0.02

110254

1.5

110630

38.0926

112040

0.0437

112141

9

112512

0.2784

112763

145.52517

110630 x 1 = 2

112763 x 7 = 14.

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

November 13, 2009 9:56:11 AM

Work Order ID: 53712



Parent Item: D3594-043RevB



Parent Item Name: Floor Doubler Assembly, LH

Start Date: 13/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21069-5

Purchased

No

170

Each

20.0000

7.0000



Anchor nuts



9/11/30

8x 50

-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

111310

20

M113627 (5x)

3x 50

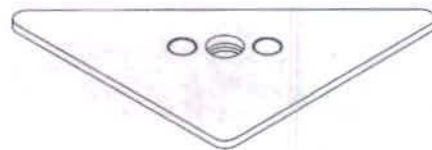
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

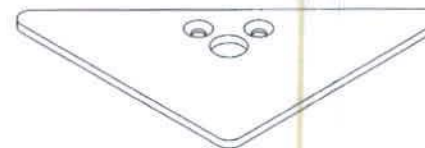
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

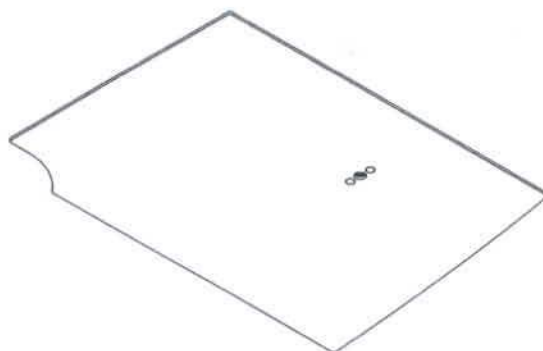
NOTE: Date & initial all entries



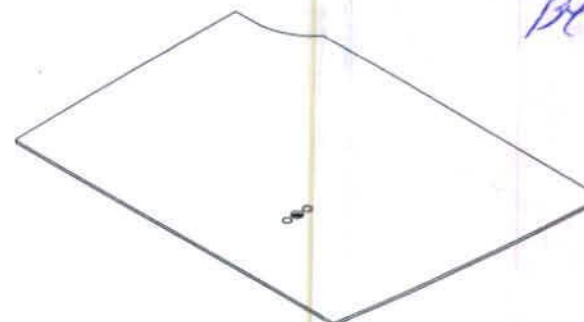
D3594-041 DOOR DOUBLER ASSEMBLY



D3594-5 DOOR DOUBLER



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

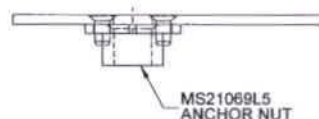
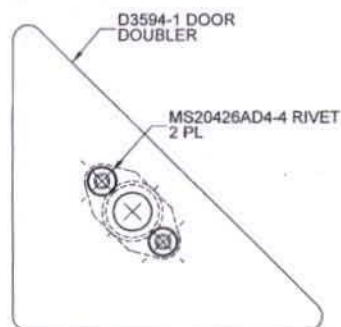
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53712

BL 09-11-13

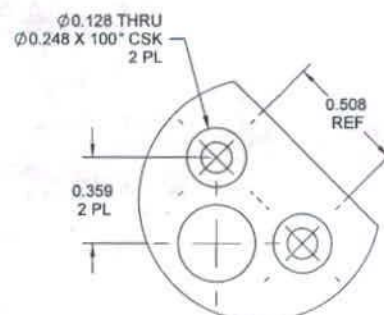
RELEASED
08.05.14

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3594 TITLE DOUBLER REV. B SHEET 1 OF 4 SCALE NTS	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
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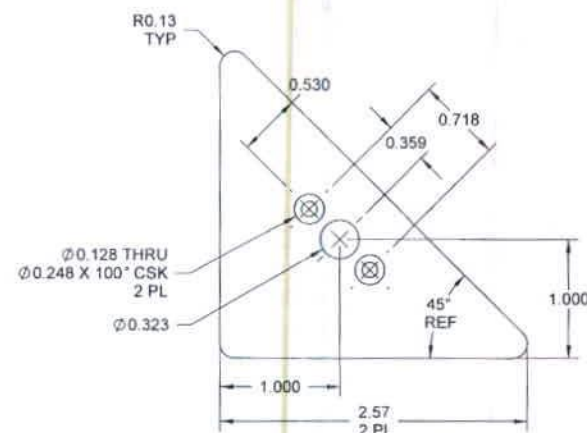
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



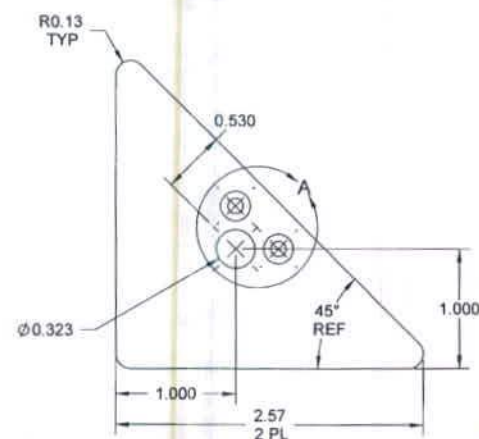
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

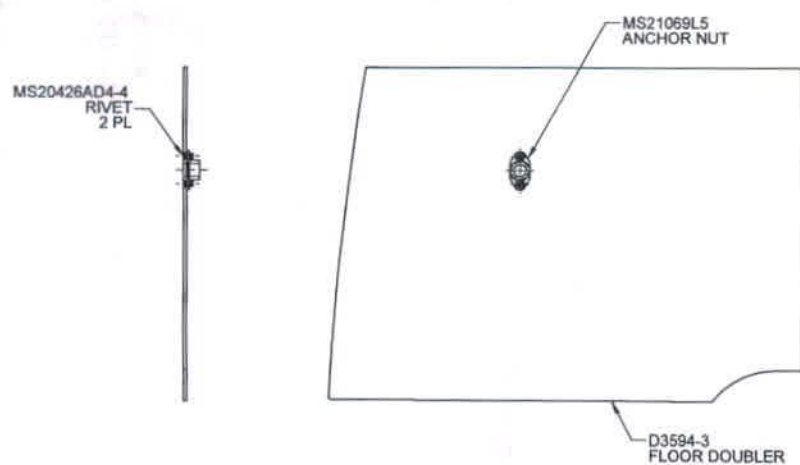
NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

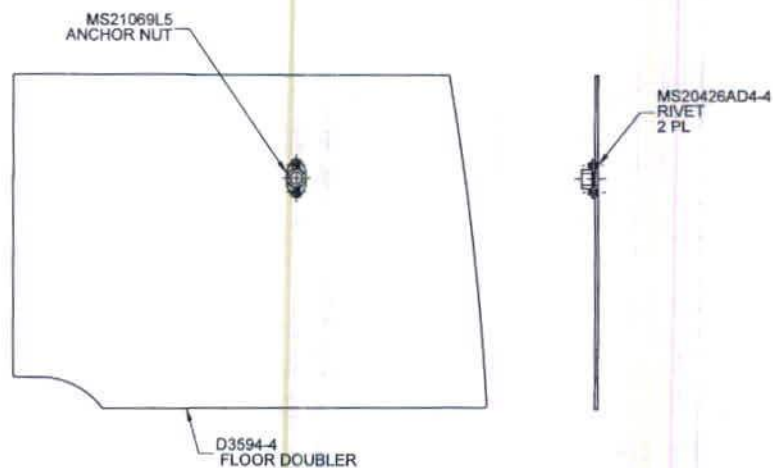
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DRAWN	AJS		
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MFG. APPR.		TITLE DOUBLER	SHEET 2 OF 4
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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

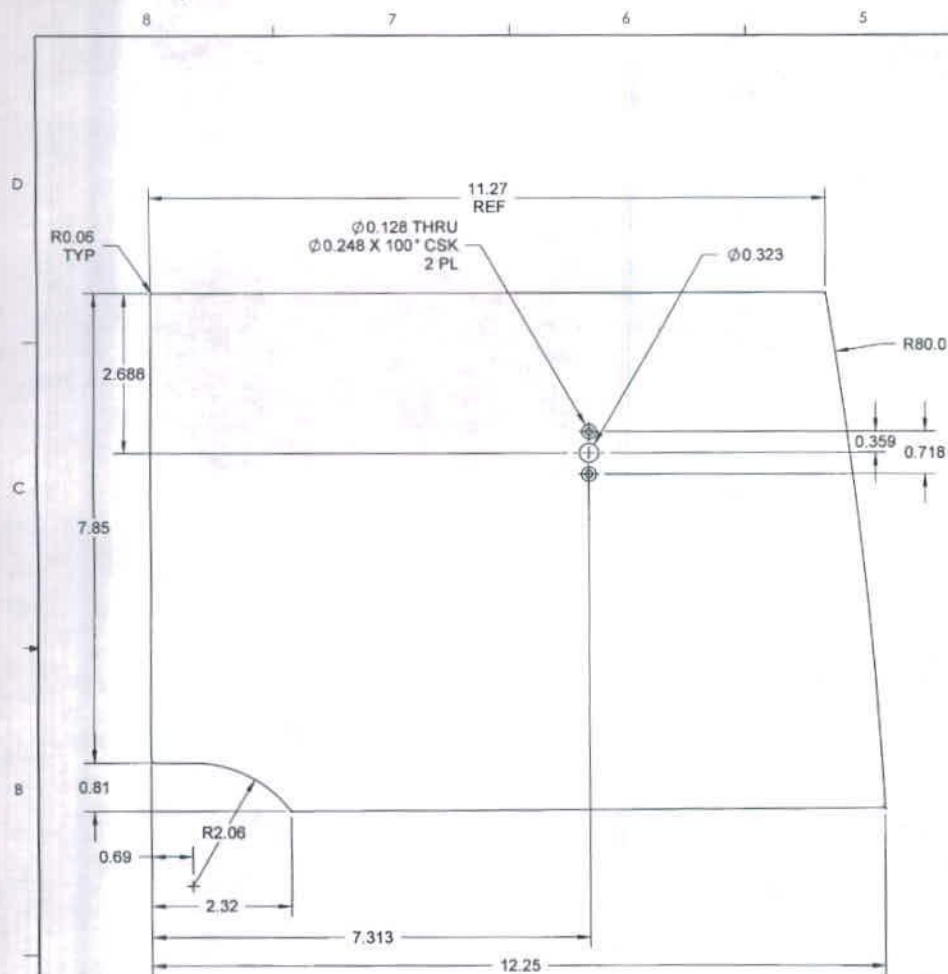
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

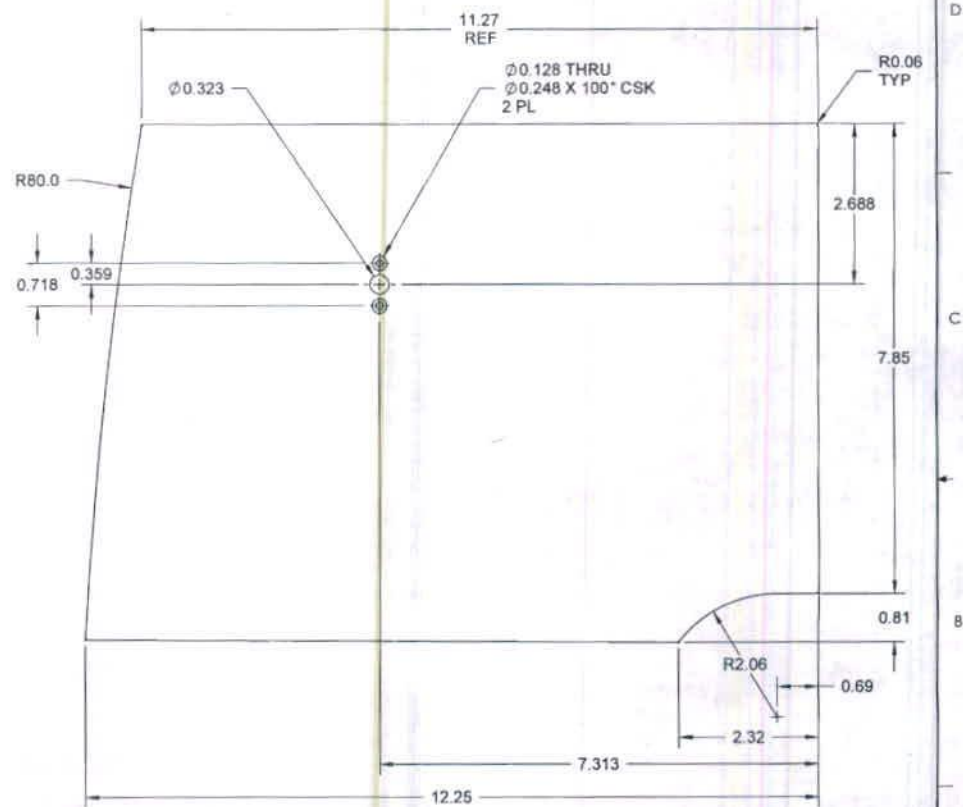
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410 53712

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D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

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